

Work Order ID 114417

March-04-14 3:05:12 PM

\*114417\*

Page 1

Item ID: D4377-1

Revision ID:

Item Name: Placard

Start Date: 04/03/2014 Start Qty: 12.00

Required Date: 04/03/2014 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: AA Date: 140305

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID      Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #      Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr      Revision Nbr

D4377      RevA

100

\*100\*

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 2329  
Manufacture as per Dwg D4377  
Possible Supplier: Studio Lettrage  
Material release note is required

0.00

0.00

C214103/10 12

110

\*110\*

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure material release note is attached

0.00

0.00

12x SP14-3-13

120

\*120\*

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

DAS

16

9-89

14103/13

612

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

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Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: ST104

0.00

\*130\*

Packaging

Memo

0.00

Packaging

12x DAS 14-03-13  
28  
9-88

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

MLJ 14-03-14

MF  
14-3-14

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Training									
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March-04-14 3:05:12 PM

Page 1

**\*114417\***

**\*D4377-1\***

**Required Qty: 12.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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**\*D4377-1P\***  
PLACARD

**\*\***

12x 14-3-13

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Material									
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Offset/Setup									
Process									
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Transport									
Unapproved									

### FAULT CATEGORY

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FONT: ARIAL WHITE  
TEXT HEIGHT: 0.08"  
WIDTH: 0.06"

TURN OFF FLASHING PULSE LIGHTS DURING PROLONGED HOVER OR  
GROUND OPERATION OVER CONCRETE OR WATER TO AVOID POSSIBLE  
PILOT DISORIENTATION. AT PILOT'S DISCRETION, TURN OFF PULSE LIGHTS  
WHEN ENTERING FOG OR HAZE TO PRECLUDE OPTICAL ILLUSIONS OR  
SPATIAL DISORIENTATION.

FONT: ARIAL WHITE  
TEXT HEIGHT: 0.06"  
WIDTH: 0.04"

D4377-1 PLACARD

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 11447  
14-03-05

RELEASED  
2011-03-25

NOTES:

- 1) MATERIAL: WHITE LETTERS AND LOGO ON BLACK ADHESIVE BACK VINYL.  
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

A		NEW ISSUE		RF	11.03.18
REV.		DESCRIPTION		BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	<del>RF</del>	DRAWING NO.		REV. A	
MFG. APPR.	<del>RF</del>	D4377		SHEET 1 OF 1	
APPROVED	<del>RF</del>	TITLE		SCALE	
DE APPR.	<del>RF</del>	PLACARD		NTS	
DATE	11.03.18	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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# Studio de Lettrage

210 Main Street W  
Hawkesbury, Ontario K6A 2H6

## INVOICE

Invoice No.: 21769  
Date: 03/10/2014  
Ship Date: 03/12/2014  
Page: 1  
Re: Order No. WO11979

### Sold to:

Dart Aerospace Ltd  
1270 Aberdeen  
Hawkesbury, Ontario K6A 1K7

### Ship to:

Dart Aerospace Ltd  
Hawkesbury, Ontario

Business No.: 82500 7651 RT0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		12	PO# 23296			
		12	D4377-1P	H	6.6667	80.00
		20	D4384-1P	H	4.0000	80.00
		12	D3499-5P	H	6.6667	80.00
			PO Chantal Lavoie			
			H - HST 13%			
			HST			31.20
Studio de Lettrage HST: #825007651RT0001						
Shipped By: Tracking Number:						
Comment:					Total Amount	271.20
Sold By:						

SP14-3-13

\*\*\*\*Certificate of Conformity\*\*\*\*

Customer:

Studio Lettrage 2001

Purchase Order #:

23296

Packing Slip #:

11979

Part #:

Serial #:

Description: D3499-SP, D4377-IP,  
D4384-IP

Quantity:

3 Batches = 44 stickers.

Certification:

We hereby certify that:

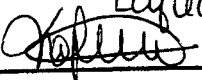
1. The above the listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

AVERY.

APPROVAL: Natasha Belinger-  
Lafleche

Signature:



Title: Job Coordinator

DATE:

March 10, 2014

## PRODUCT DATA SHEET



### Avery® IPM™ 2031

issued: 01/04/2005

#### Introduction

Avery® IPM™ 2031 is a high quality pressure-sensitive vinyl film, designed for use on wide format inkjet printers. Avery® IPM™ 2031 has excellent printing properties, allowing crisp print quality with bright and vibrant colours. Avery® IPM™ 2031 offers rapid ink drying and a water-resistant material. It combines good adhesion during its life and easy removal afterwards.

#### Description

Facefilm: 80-micron premium white calendered, topcoated vinyl.  
Adhesive: removable, acrylic based  
Backing paper: one side coated kraft paper, 140 g/m<sup>2</sup>

#### Features

- Excellent printability
- Vibrant and bright colours
- Crisp print quality
- Spray water resistant with specific pigmented inks
- Good adhesion, excellent removability
- Warranty on outdoor durability

#### Recommendations for use

A wide variety of full-colour graphics for indoor - and **short/medium term outdoor** applications such as posters, murals, displays, exhibition stands, vehicle graphics etc. Avery® IPM™ 2031 is suitable for application to a wide variety of substrates and will remove cleanly for up to 1 year after application.

IPM media should be handled with care as any surface contamination may affect the print quality. Media should be processed in an environment of 15-25°C and 30-70% relative humidity. After drying, the finished prints should be wrapped in polyethylene film and despatched flat or rolled with the printed side facing outwards. To protect prints against water, UV/light and abrasion, overlamination with a clear film is recommended. For specific details of Avery® DOL combinations, refer to "Technical Bulletin 5.3. Recommended combinations of Avery® Overlaminates and Avery® Digital Print Media"

**Always test your combination of Avery® IPM™ medium, inkjet printer and inks prior to commercial use.**

#### Compatibility

Avery® IPM™ 2031 is compatible with a broad selection of inkjet printers, when printing with pigmented, water based inks. For specific details refer to "Technical Bulletin 5.6 Avery Dennison Inkjet Print Media - Printer compatibility".

#### Durability:

Avery® IPM™ 2031 is warranted for outdoor use in conjunction with pigmented outdoor inks from HP, Encad and Colorspan. The warranted period varies from type of application and type of overlaminate from 18 months up to 5 years. For full details, see our Avery® IPM™ Outdoor warranty.



www.averygraphics.com

Graphics Division  
Rijndijk 86, P.O. Box 116  
2304 ZG Hazerswoude - The Netherlands  
Tel +31 71 3421500 - Fax +31 71 3421538

## PRODUCT CHARACTERISTICS

Avery® IPM™ 2001

### Physical properties

Features	Test method <sup>1</sup>	Results
Caliper, facefilm	ISO 534	80 µm
Gloss	ISO 2813, 20°	1%
Dimensional stability	DIN 30646	0.3 mm. max
Adhesion, initial	FINAT FTM-1, stainless steel	180 N/m
Adhesion, ultimate	FINAT FTM-1, stainless steel	260 N/m
Flammability		Self extinguishing
Accelerating ageing	DIN 53587, 500h exposure	No negative impact on film Performance
Shelf life	Stored at 22° C/50-55 % RH	2 years
Removability		up to 1 year
Not when applied to: Nitro-cellulose paints, ABS, Polystyrene, certain types of PVC		
Durability <sup>2</sup>	Overlaminated with DOL 4300	5 years
	Overlaminated with DOL 1000, DOL 1100 with overlaps	3 years
	Overlaminated without overlaps for static applications only	2 years
	Without overlaminate and used for static, Non-abrasive application ONLY	18 months

Only when printed with ENCAD GO, HP and Colorspan pigmented inks and when properly applied in accordance with our application instructions. Only applicable for vertical exposure.

### Temperature range

Features	Results
Application temperature	Minimum: +10°C
Service temperature	-20°C to +80°C

#### Important

Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use.

All technical data are subject to change. In case of any ambiguities or differences between the English and foreign versions of these Conditions, the English version shall be controlling.

#### Warranty

Avery® branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing.

All Avery® branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

#### 1) Test methods

More information about our test methods can be found on our website.

#### 2) Durability

The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.



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Tel +31 71 3421500 - Fax +31 71 3421533



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO23296**

Purchase Order Date 3/10/2014

PO Print Date 3/10/2014

Page Number 1 of 2

**Order From :**

STUDIO DE LETTRAGE 2001  
210 MAIN WEST  
HAWKESBURY, ON K6A 2H6  
CA

VC-STU001

**Ship To :** DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
6/14/2010

**Contact Name**

**Vendor Phone** 613 632 5449

**Ship To Contact**

**Ship To Phone**

**Ship Via:** Yours ppd

**Ship Acct:**

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #** 10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pr
1	D3499-5P  AS PER DWG D3499 REV. C B114408	Placard	3/14/2014 Yes 3/14/2014		12.00 ✓ Each	\$6.67	\$80.
						<b>Line Total:</b>	<b>\$80.</b>
2	D4377-1P  AS PER DWG D4377 REV. A B114417	PLACARD	3/14/2014 Yes 3/14/2014		12.00 ✓ Each	\$6.67	\$80.
						<b>Line Total:</b>	<b>\$80.</b>
3	D4384-1P  AS PER DWG D4384 REV. A B114111	Placard	3/14/2014 Yes 3/14/2014		20.00 ✓ Each	\$4.00	\$80.

**Note:**

3/10/2014

SP 14-3-13.